NCR:	· ·													
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Work Ord	er:						DISPOSITION			AGAINST I	DEP	ARTMENT/	PROCESS	
	Part No						Rework Scrap Use-as-is		Skid-tube Crosstube  Machining Small Fab  Thermoforming Finishing				Water Jet d. Eng. Coor. e/Packaging	Engineering Quality Other
NCR	NO.						Work Order Update	]		Large Fab Composite			Supplier	l —— —— —— —— —— —— —— —— —— —— —— —— ——
Root					Desc	rip	ription of work order update			nitial Action				•
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		Cracks			-	_	Broken/Damaged		l '	ion Incomplete	—	Part Incorrec	<b>⊢</b>	Weld
		Crushed/0	Crimped.				Burrs		1	ions Incomplete/Unclear	$\dashv$	Part Lost/Mi	ssing	Wrong Stock Pulled
		Cuffs Contamination					Contamination		Mainte			Part Moved		
		Heat Treat Countersink					Countersink		Mislabe	eled	-	Positioned V		-
		Inspection Strip in Tube Cut Too Short						<u></u>	Misrea	d	:	Power Loss/	Surge	Other
	Ripples in Bend Drill Holes					Drill Holes		Offset		_				
	Torque Waves in Extrusion Drawing						Drawing	Out of Calibration						
•	Turning Sequence Finish						Finish	Out of Sequence						
	Wave/Twist in Tube Folio						Folio		Outside Dimensions					

DQA: Date:

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Orde Wednesday, Apr				*100	<b>1076*</b>				Page 2	
Item ID: Revision ID: Item Name:	D4062-041 Tank Support	Assembly		Accept	*N900040	100	*	Setup Sta	ıv	S1* S2*
Start Date: 4/17/2013 Required Date: 4/26/2013 Reference:		Start Qty: 5.00 Req'd Qty: 5.00	*5* *5*		Cust Item ID: Customer:				IN	.J/
Approvals:	Process Pla	n:	Date:	Tooling: SPC (Y/N):	Date:			Run Sta Sto	1/1	R1* R2*
Sequence ID/ Work Center II 130 *130*	)	Operation Description Identify as per dwg & Stoc	k Location	Set Up/ Run Hours	Tool ID Tool #		Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Packaging Packaging		Memo		0.00		-	12			13.06.12
*140		QC21- Final Inspection - V	Vork Order Release	0.00			l	3/6	19	*
QC Quality Control		Memo		0.00		-				

M/ 6 - 18

			•	DQA:	Date:	
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											QA Closed:	Date:	
Work Orde	er.					DISPOSITION				AGAINST DI	EPARTMENT	/PROCESS	•
Part N	No					Rework Scrap Use-as-is Work Order Update	ap Machining Small Fab Prod. Eng. Coor. Qu -is Thermoforming Finishing Rec/Store/Packaging C						Engineering Quality Other
Root *					Descri	ption of work order update	T	nitial	Ac	tion	Sign &		
Cause		Date <sup>-</sup>	Step	Qty	Į.	or Non-conformance	Ch	ief Eng	Desc	cription	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved								z					
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Landi	Ce Cr Cr Cu He Ins Rip To	nding ntre No acks  ushed/C ffs at Trea pection oples in rque W rning Se	t Strip in Bend aves in E	Tube Extrusio		General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes Drawing Finish		Instruct Mainte Mislabe Misrea Offset Out of	tion Incomplete tions Incomplete/ enance eled d Calibration Sequence	/Unclear	Ovalized Over/Under Part Incorre Part Lost/M Part Moved Positioned V Power Loss	ct ssing Wrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
ı	Wave/Twist in Tube					Folio	- 1	Outside Dimensions					

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**Picklist Print** 

Wednesday, April 17, 2013 4:08:16 PM

Work Order ID:

100076

Parent Item:

D4062-041

Parent Item Name:

Tank Support Assembly

**Start Date:** 4/17/2013

**Required Date: 4/26/2013** 

Page 1

Start Qty: 5.00

Required Qty: 5.00

**Comments:** 

IPP REV:A NEW ISSUE 11-11-23 JLM VERIFIED BY:DD

IPP REV:B AS PER REV C 12-

	03-08 JLM VERI	FIED BY:DD											
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4062-1 Upper Tank Support	<b>P</b>	Manufactured	No	,		í.	Each	4.0000		5	-12	13.0	06.17
		B10012 B1000	39 = ( 17=1	Location WA	eer c	Loc Qty 4	<u>Lo</u>	c Code	` 4	46			
D4062-3		Manufactured	No No	906	27 <b>100078</b>	4	Each	1.0000		16	04		. 5
Lower Tank Support				Location		Loc Oty	<u>Lo</u>	c Code	<del>~</del>		-1(1	<u> 3 · UU</u>	2.12
·		B10019 B10007	0=	WA003 B		1				6 11	e e e e e e e e e e e e e e e e e e e		
		B10007	8={		iced 11			1	.*	•			

DQA:	Date:	
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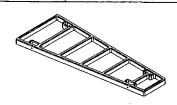
NCR: Yes / No

## WORK ORDER NON-CONFORMANCE / UPDATE

			<u>.</u>						QA Closed:	Date:	
Work Orde	r·				DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	
Part No	0.				Rework Scrap Use-as-is Work Order Update	1 5	Skid-tube  Machining  moforming  Large Fab	Crosstube Small Fab Finishing Composite	4	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root				1	iption of work order update	Initial	i	ction	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chief Eng	Desc	ription	Date	Verification	QC Inspector
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Landin	g Gear  Bending  Centre Note Cracks  Crushed/  Cuffs  Heat Treat  Inspection  Ripples in  Torque W  Turning S  Wave/Tw	Crimped at n Strip in n Bend Vaves in E equence	Tube		General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes Drawing Finish Folio	Instruc Mainte Mislab Misrea Offset Out of	tion Incomplete tions Incomplete, enance eled	/Unclear	Ovalized Over/Under Part Incorre Part Lost/M Part Moved Positioned V	ct sissing Wrong	Pressure/Forced Temperature/Cure Weld. Wrong Stock Pulled Other

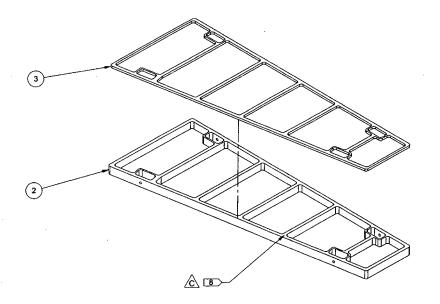
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ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION
1	х	D4062-041	TANK SUPPORT ASSEMBLY
2	1	` D4062-1	LOWER TANK SUPPORT
3	1	D4062-3	UPPER TANK SUPPORT



С

В



## **D4062-041 TANK SUPPORT ASSEMBLY**

NOTES:
1) MATERIAL: N/A
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 2.91 lbs
8) BOND ITEMS 2 & 3 TOGETHER USING PROSEAL 890 OR MIL-S-8802 CLASS B2 SEALANT

REV.	DESCRIPTION	BY	DATE
Α	NEW ISSUE	HS	10.07.26
В	MODIFIED DIMS & DESIGN OF -1, ADDED -3/-041	DC	11.09.29
С	REMOVE HARDWARE TO ATTACH ITEMS 2 & 3. REMOVE C'BORE.	DC	11.12.14

DESIGN	<b>5</b>	J DART AEROSPA	CELTD
DRAWN	SC	HAWKESBURY, ONTARK	
CHECKED	85	DRAWING NO.	REV. C
MFG. APPR.	B	D4062	SHEET 1 OF 3
APPROVED	NA	TITLE	SCALE
DE APPR.	-#	TANK SUPPORT	NTS
DATE 11.1	2.14	COPYRIGHT © 2010 BY DART AE THIS DOCUMENT IS PRIVATE AND COMMERCITIAL AND IS SUPPLIED OF NOT TO BE USED FOR ANY PURPOSE OR COMPEDIO NO COMMERCENT WATETITY PROMISSION FROM PART AEROS	IN THE EXPRESS CONDITION THAT IT IS ED TO ANY OTHER PERSON WITHOUT

												DQA:	Date	:		
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Part						Rework Scrap Use-as-is	Skid-tube Crosstube Small Fab Thermoforming Finishing				Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other				
NCR	No.					Work Order Update Large Fab Composite				site		Supplier _				
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		Bending			<u> </u>	Bend		Grain				Ovalized	-	Pressure/Forced		
	L	Centre No	ot Concer	ntric to	o/s	BOM/Route	L	Hardwa				Over/Under	<b>-</b>	Temperature/Cu	re	
	Cracks					Broken/Damaged	_	1 '	ion Incomplete			Part Incorre	<b> </b>	Weld		
	Crushed/Crimped					Burrs	$\vdash$	-	ions Incomplete,	/Unclear	<u> </u>	Part Lost/M		Wrong Stock Pul	led	
	L	Cuffs				Contamination	$\vdash$	Maintenance F				Part Moved				
		Heat Trea	it			Countersink		Mislabe	eled		<u> </u>	Positioned Wrong		_		
1		Inspection	n Strip in	Tube		Cut Too Short	Misread					Power Loss/	'Surge	Other		

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

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Turning Sequence

Wave/Twist in Tube

Ripples in Bend

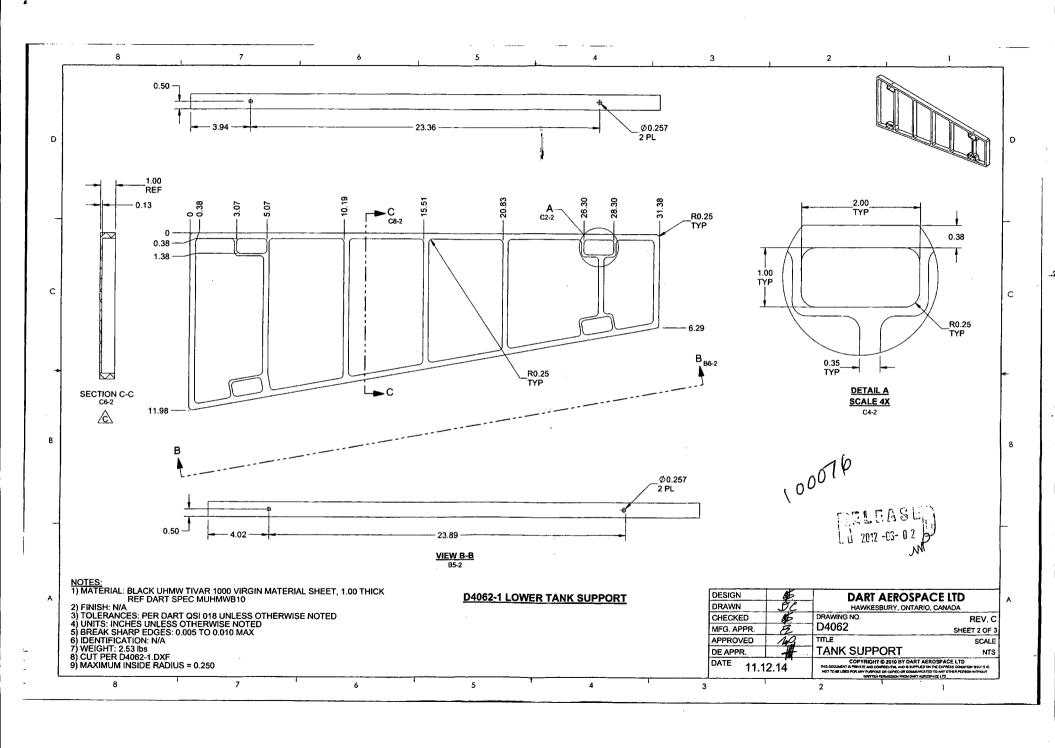
Torque Waves in Extrusion

Drill Holes

Drawing

Finish

Folio



										DQA:	Date	
NCR:	Yes	/ No				WORK ORDER NON-	CONFORI	MANCE / UP	DATE	QA Closed:	Date	
Work Ord	or:		. ·			DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	
Part						Rework Skid-tube Machining Use-as-is Thermoforming			Crosstube Small Fab Finishing	4	Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other
NCR No.						Work Order Update Large Fab Composite					Supplier	
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	Cracks					Broken/Damaged	Inspect	tion Incomplete		Part Incorre	ct	Weld
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	Г	Inspectio	n Strin in	Tube		Cut Too Short	Misrea	d		Power Loss	/Surge	Other

Offset

Out of Calibration
Out of Sequence

Outside Dimensions

Ripples in Bend

Turning Sequence

Wave/Twist in Tube

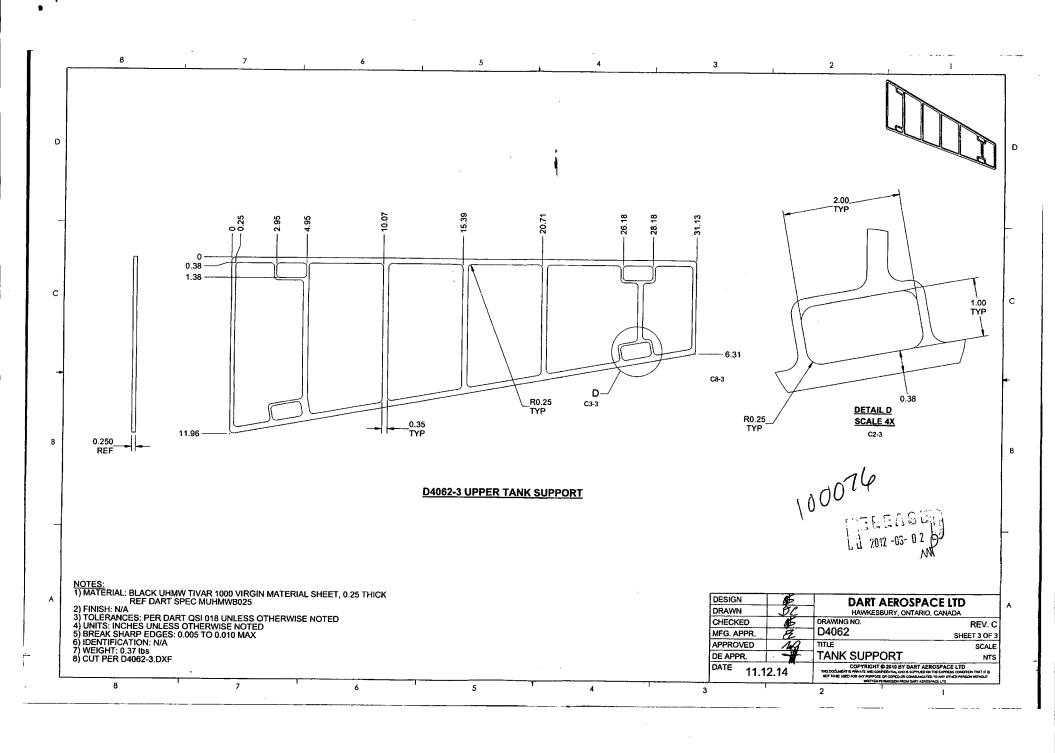
Torque Waves in Extrusion

Drill Holes

Drawing

Finish Folio

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Work Order:  Part No.  NCR No.					Rework Scrap Use-as-is Work Order Update		Skid-tube Crosstube Machining Small Fab Thermoforming Finishing Composite			<b>-</b>	Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier		Engineering Quality Other
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	Cracks				Broken/Damaged	$\vdash$	Inspection Incomplete			Part Inco		—	Weld
	Crushed/Crimped				Burrs	Instructions Incomplete/Unc			/Unclear	Part Lost,	_	'لـــ	Wrong Stock Pulled
	Cuffs				Contamination	<del></del>				Part Moved			
	Heat Treat				Countersink	- <del> </del>			Positione		0.1		
	Inspection Strip in Tube				Cut Too Short	Misread			Power Lo	ss/Surge	, l'	Other	

Offset

Out of Calibration
Out of Sequence

Outside Dimensions

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

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